

Dr:  
User:Wednesday, 3/26/2008 10:03:59 AM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TURNING DETAIL FOR D2892-1
Job Number : 38203	
Estimate Number : 13233	
P.O. Number :	Part Number : DSK077
This Issue : 3/26/2008 S.O. No. :	Drawing Number : DSK077 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 38130	Material :
Written By :	Due Date : 4/15/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JD 08.3.27</u>	
Comment : est rev A. 08.03.13 new issue EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6104003 17-4 SS Roundbar 3.25"OD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

Batch: B 38209RD 08/09/112.0 ~~MORI SEIKI~~ DOOSAN

MORI SEIKI CNC LATHE LARG

Comment: ~~MORI SEIKI~~ LATHE

Turn blank as per Folio FA082

mk 08/04/12

10

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 08/04/12

10

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

RD 08-04-12

10

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: \_\_\_\_\_

mk 08/04/12

(10)

6.0 QC21 FINAL INSPECTION/W/O RELEASE

08/04/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

U 08-04-14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

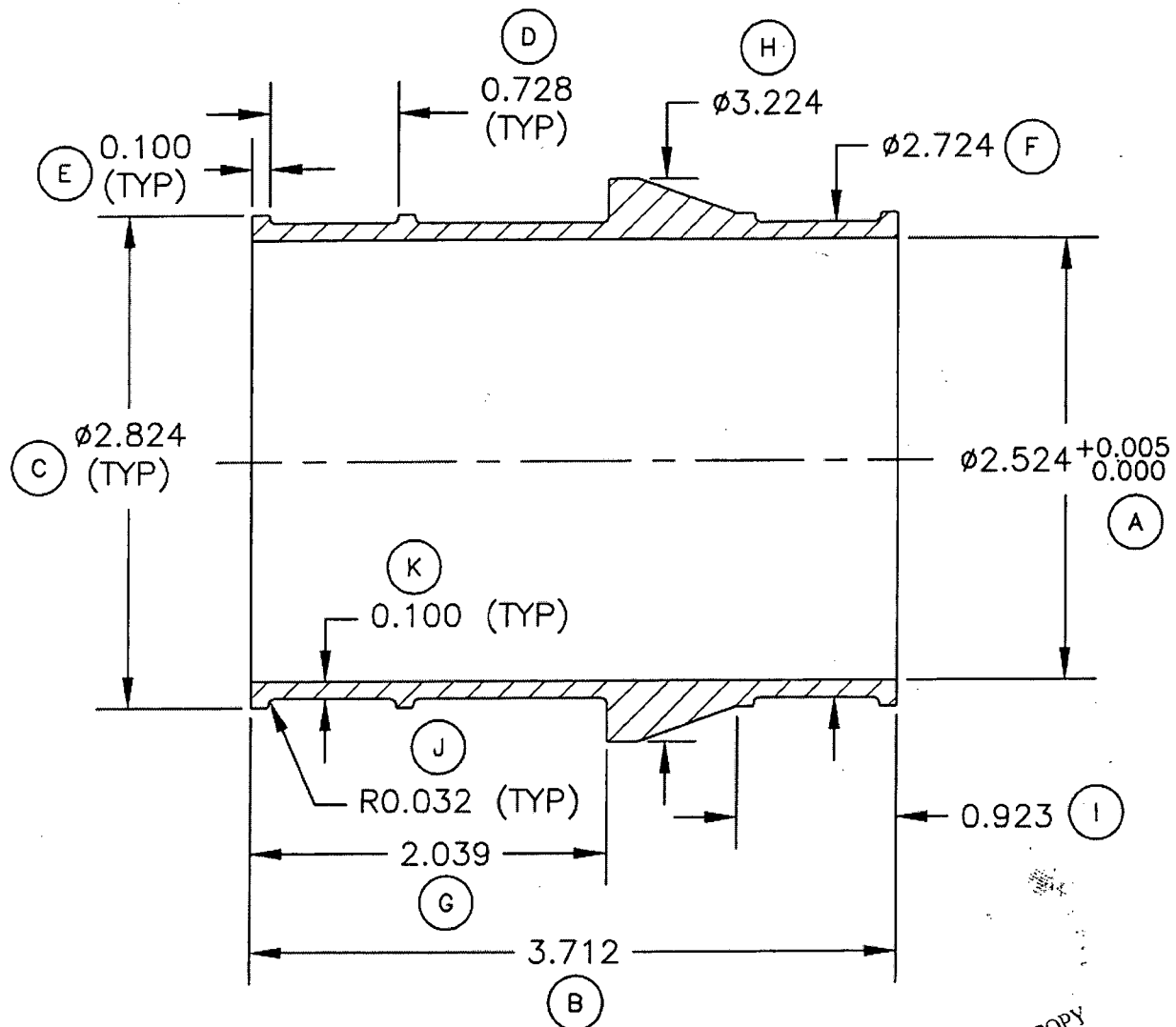
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 077	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2892-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
03.07.01



D2892-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 38203

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<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38 203
<b>Description:</b> Ø2.500 Support	<b>Part Number:</b> D2892-1
<b>Inspection Dwg:</b> D2892 Rev. A	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
<b>Lathe Section</b>									
A	2.524	2.529		2.524	2.525	2.525	2.525		
B	3.702	3.722		3.710	3.710	3.712	3.712		
C	2.814	2.834		2.825	2.823	2.824	2.823		
D	0.718	0.738		.725	.726	.727	.725		
E	0.090	0.110		.101	.100	.101	.101		
F	2.714	2.734		2.725	2.722	2.720	2.722		
G	2.029	2.049		2.036	2.038	2.038	2.036		
H	3.214	3.234		3.223	3.222	3.222	3.222		
I	0.913	0.933		.928	.927	.925	.925		
J	0.022	0.042		.032	.032	.032	.032		
K	0.090	0.110		.100	.099	.098	.099		
L									
<b>HAAS Section</b>									
AA	0.115	0.135							
AB	0.290	0.310							
AC	0.040	0.060							
AD	0.115	0.135							
AE	0.240	0.260							
AF	0.188	0.193	DT8706						
AG	0.240	0.260							
AH	1.126	1.146							
AI	0.454	0.474							
AJ	0.240	0.260							
AK	0.053	0.073							
AL	0.257	0.262	DT8683						
AM	1.663	1.683							
AN	0.053	0.073							
AO	0.022	0.042							
AP	2.779	2.789							
AQ									
AR									
<b>Accept/Reject</b>									

Measured by:	<i>mk</i>
Date:	08/04/12

Audited by:	<i>Br</i>
Date:	08.04.12

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	<i>[Signature]</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38203
<b>Description:</b> Ø2.500 Support		<b>Part Number:</b> D2892-1
<b>Inspection Dwg:</b> D2892 Rev. A		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				#5	#6	#7	#8		
<b>Lathe Section</b>									
A	2.524	2.529		2.525	2.525	2.525	2.525		
B	3.702	3.722		3.712	3.711	3.712	3.712		
C	2.814	2.834		2.823	2.824	2.824	2.824		
D	0.718	0.738		.725	.725	.723	.724		
E	0.090	0.110		.101	.100	.100	.101		
F	2.714	2.734		2.722	2.722	2.721	2.722		
G	2.029	2.049		2.040	2.037	2.037	2.038		
H	3.214	3.234		3.222	3.222	3.222	3.222		
I	0.913	0.933		.923	.924	.924	.924		
J	0.022	0.042		.032	.032	.032	.032		
K	0.090	0.110		.099	.099	.099	.099		
L									
<b>HAAS Section</b>									
AA	0.115	0.135							
AB	0.290	0.310							
AC	0.040	0.060							
AD	0.115	0.135							
AE	0.240	0.260							
AF	0.188	0.193	DT8706						
AG	0.240	0.260							
AH	1.126	1.146							
AI	0.454	0.474							
AJ	0.240	0.260							
AK	0.053	0.073							
AL	0.257	0.262	DT8683						
AM	1.663	1.683							
AN	0.053	0.073							
AO	0.022	0.042							
AP	2.779	2.789							
AQ									
AR									
<b>Accept/Reject</b>									

Measured by:	cmk
Date:	08/04/12

Audited by:	AK
Date:	08.04.12

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	✱

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 38203
<b>Description:</b> Ø2.500 Support	<b>Part Number:</b> D2892-1
<b>Inspection Dwg:</b> D2892 Rev. A	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2892 Rev. A/DSK077 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				9	10	8	4		
<b>Lathe Section</b>									
A	2.524	2.529		2.525	2.525				
B	3.702	3.722		3.713	3.712				
C	2.814	2.834		2.825	2.824				
D	0.718	0.738		.723	.723				
E	0.090	0.110		.100	.100				
F	2.714	2.734		2.723	2.722				
G	2.029	2.049		2.038	2.037				
H	3.214	3.234		3.222	3.222				
I	0.913	0.933		.926	.927				
J	0.022	0.042		.032	.032				
K	0.090	0.110		.099	.099				
L									
<b>HAAS Section</b>									
AA	0.115	0.135							
AB	0.290	0.310							
AC	0.040	0.060							
AD	0.115	0.135							
AE	0.240	0.260							
AF	0.188	0.193	DT8706						
AG	0.240	0.260							
AH	1.126	1.146							
AI	0.454	0.474							
AJ	0.240	0.260							
AK	0.053	0.073							
AL	0.257	0.262	DT8683						
AM	1.663	1.683							
AN	0.053	0.073							
AO	0.022	0.042							
AP	2.779	2.789							
AQ									
AR									
<b>Accept/Reject</b>									

N/A  
02.04.12

Measured by:	gmk
Date:	02/04/12

Audited by:	RF
Date:	02.04.12

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	RF